

SF1449 CONTINUATION SHEET	REFERENCE NO. OF DOCUMENT BEING CONTINUED N00253-04-Q-0043, Amendment 0001	PAGE 2	OF
NAME OF OFFEROR OR CONTRACTOR			

Question 1: I have printed out the PDF documents and we are concerned about the casting tolerances called out. They are tighter than the machining specifications. Typical green sand casting tolerances are plus/minus 0.030" per inch. Typical no-bake casting tolerances are plus/minus 0.015" per inch. The specifications on the drawing for the casting are plus/minus 0.010 for the 1st inch and then 0.005" after that. Machining call out plus/minus 0.030" on 2 decimal place dimension and 0.010" on 3 decimal places. What casting process are you looking for on this quote?

Answer 1: The main purpose of the tight casting tolerance on the drawing was to ensure that we could maintain the proper wall thickness even with core shift. The value of the tolerance was based on use of an investment casting process; however any process that could meet the tolerance by itself or by over-sizing the part and machining the casting back to the stated casting tolerance would be acceptable. The block tolerance only applies to written dimensions that do not specify a local tolerance.